

ShearAngle Profile Tool Ø130 Z4

A16-200

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels and automatic calculation of the wheel orientation to achieve the required radial and axial clearance. Probing is measuring Shear-, Rakeangle and division if necessary.

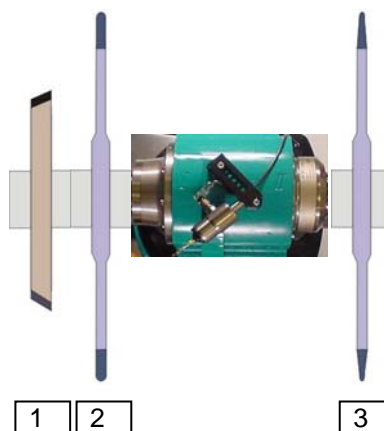
1. Cycletime for Production

Workpiece: Ø 130 mm, Z 4, Length of cutting edge 48 mm, shear angle 5° Material CARBIDE					
Operations	Probe	Flute 1	Prf Rough	Prf Pgrd	Prf fin
Feed [mm/Min]	2000	70	90	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	3
Grinding time [s]	30	260	2027	280	201
Total cycle time	46 Min 38				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	14EE1 Ø200 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG **Coolant:** Synthetic Oil, pressure 6 bar
Control: Fanuc 310i **Software:** Quinto 5
Accessories:

Responsible engineer: OP. 3.8.10

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China